

WELD PER EPS-1003 CLASS C AS SHOWN			SHEET	REV	ECO	DATE	DESCRIPTION	BY	APR	CHK
			1	A		03/12/97	REMOVED 206IR-2105 BEAMS & HARDWARE	REB	REB	REB
			1	B		11/03/00	UPDATED FORMAT AND DRAFTING	MR	MR	LS
			1-5	C		01/12/05	SHT1: DIMS 14.75, 13.0, 9.0, & 4.0 WERE ± 0.010 , WELDS WERE CONTINUOUS. SHT3: 21.0° WAS 21.467°.	REB	REB	LS
			1,2	D		08/18/08	03/22/06: SHT1: ADDED 1.410±0.020, 8.875±0.020, 8.875 (REF), 6.85±0.02 DIMS; DIM 1.027 WAS 0.938, REMOVED 7.875, MOVED IF2723 FINISH FROM SHT2 TO SHT1. ADDED NOTE TO -11 CALLOUT. 08/18/08: CARDINAL C241-BK303 WAS HB FULLER CO. IF-2723.	REB	REB	LS
			1-5	E		01/19/2011	ADDED PREDRILL #0.170 IN -13, ADDED -14 SPECIFICATION AMS-WW-T-700/6 WAS INDICATED AS QQ-A-250/11 SPECIFICATION AMS-QQ-A-200/1 WAS INDICATED AS QQ-A-20/16	REB	REB	LS
			1	F		08/16/2019	REMOVED FINISH NOTE FROM -1 ASSEMBLY.	DT	✓PJKS	

STITCH WELD ALL ADJOINING SURFACES AS SHOWN
MIN LENGTH 0.75
(TYP. 12 PLCS)

IR-1110-10 TUBE

CENTER LINE

-1 ASSEMBLY
NOTE ORIENTATION

IR-1110-13 ANGLE(1X)

IR-1110-14 ANGLE(3X)

IR-1110-12 RING

IR-1110-11 RING

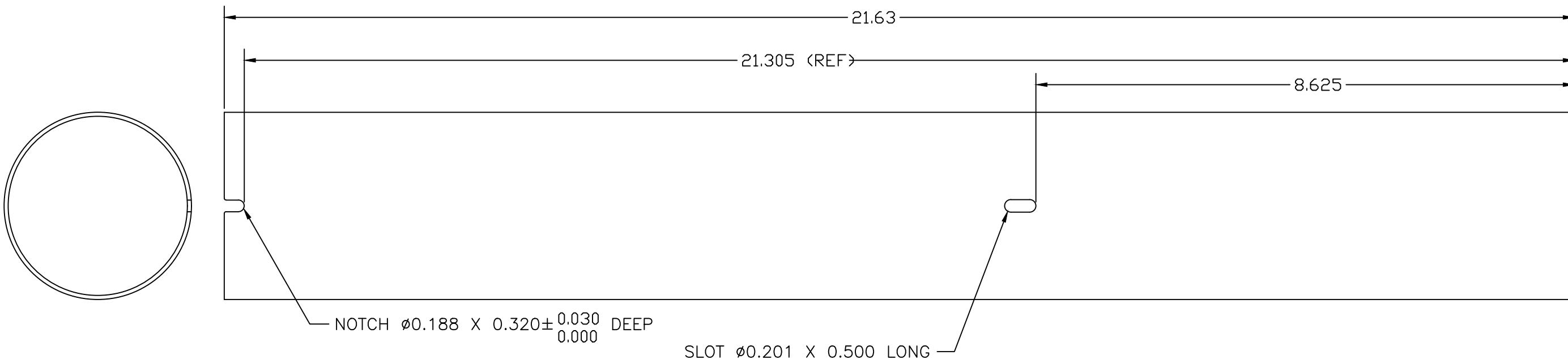
ALIGN TUBE & RING
SLOTS BEFORE WELDING.

BREAK ALL SHARP EDGES

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3	IR-1110-14	ANGLE	
1	IR-1110-13	ANGLE	
1	IR-1110-12	RING	
1	IR-1110-11	RING	
1	IR-1110-10	TUBE	
ASSY		PART NUMBER	DESCRIPTION
QTY.	Paravion [®] ✓ Technology Inc.	TITLE SUPPORT ASSEMBLY	
DIMENSIONS IN INCHES		DRAWN BY	
TOLERANCES EXCEPT WHERE NOTED:		APRVD. BY	CHK'D. BY
.X. = $\pm .1$.XX = $\pm .05$.XXX = $\pm .010$		DATE	REV
ANGLES = $\pm 1^\circ$		09/06/96	ECO
		DO NOT SCALE DRAWING	
		SHEET	
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		1 OF 5	

MATERIAL: 6061-T6; AMS-WW-T-700/6, AMS4080, AMS4082
 STOCK: $\varnothing 3$ X 0.065 WALL TUBE
 WEIGHT: 1.34 lbs
 SURFACE FINISH $125\text{ }\mu\text{in}$



-10 TUBE

BREAK ALL SHARP EDGES

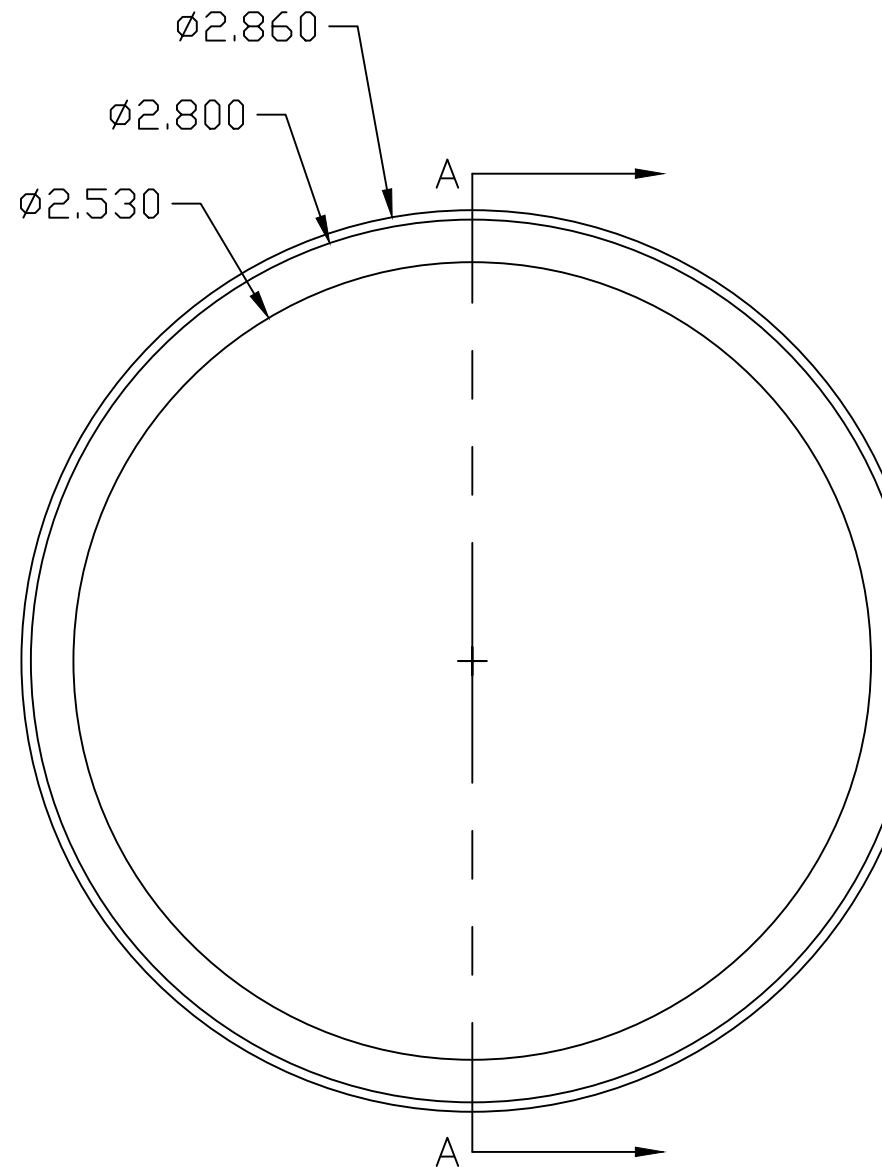
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PROTO

N/C

Paravion® Technology	TITLE			DRAWING NO.						
	SUPPORT ASSEMBLY			IR-1110						
DIMENSIONS IN INCHES										
TOLERANCES EXCEPT WHERE NOTED:										
.X	$\pm .1$									
.XX	$\pm .05$									
.XXX	$\pm .010$									
DO NOT SCALE DRAWING										
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				2 OF 5						
DRAWN BY	APRVD. BY	CHK'D BY	DATE	REV	ECO					
RHSM	REB	REB	09/06/96	F						

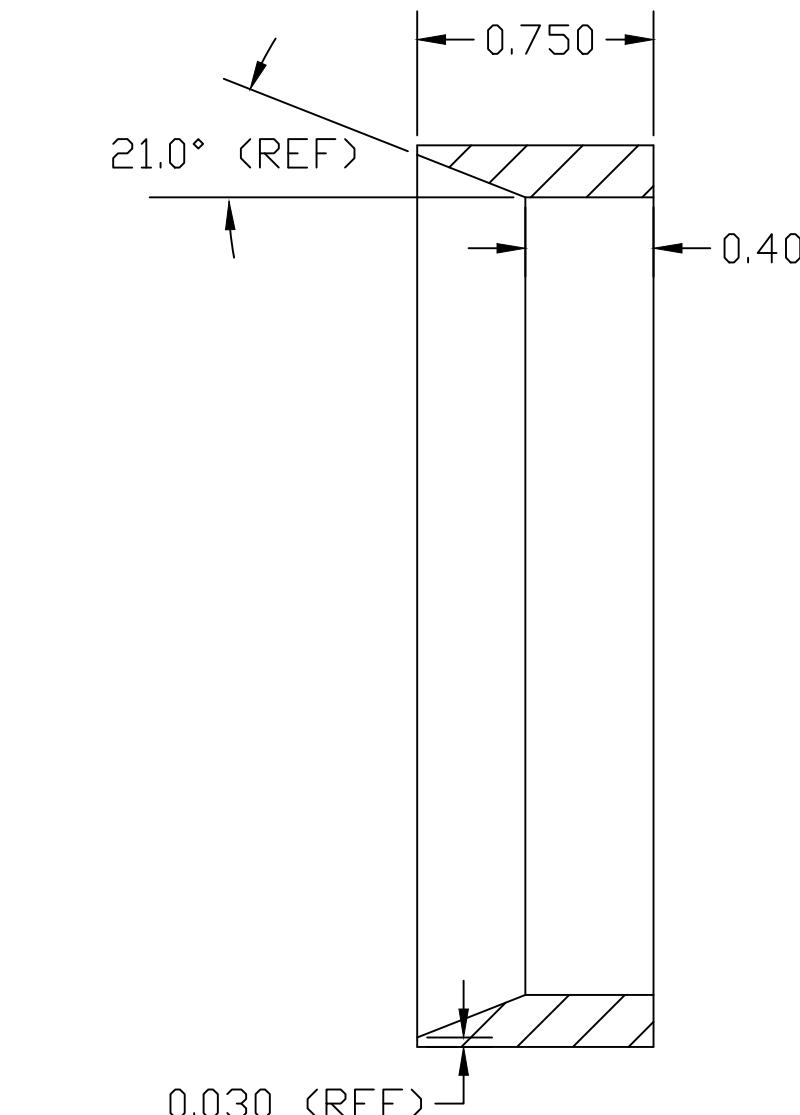
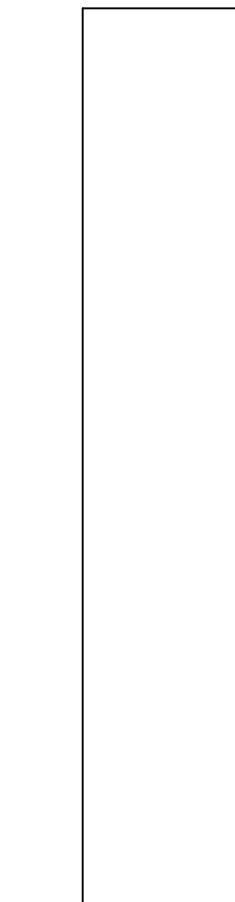
MATERIAL: 6061-T6; AMS-WW-T-700/6, AMS4080, AMS4082
 STOCK: 3" X 0.375 WALL TUBE
 WEIGHT: 0.11 lbs
 SURFACE FINISH $125\text{ }\mu\text{in}$



-12 RING

BREAK ALL SHARP EDGES

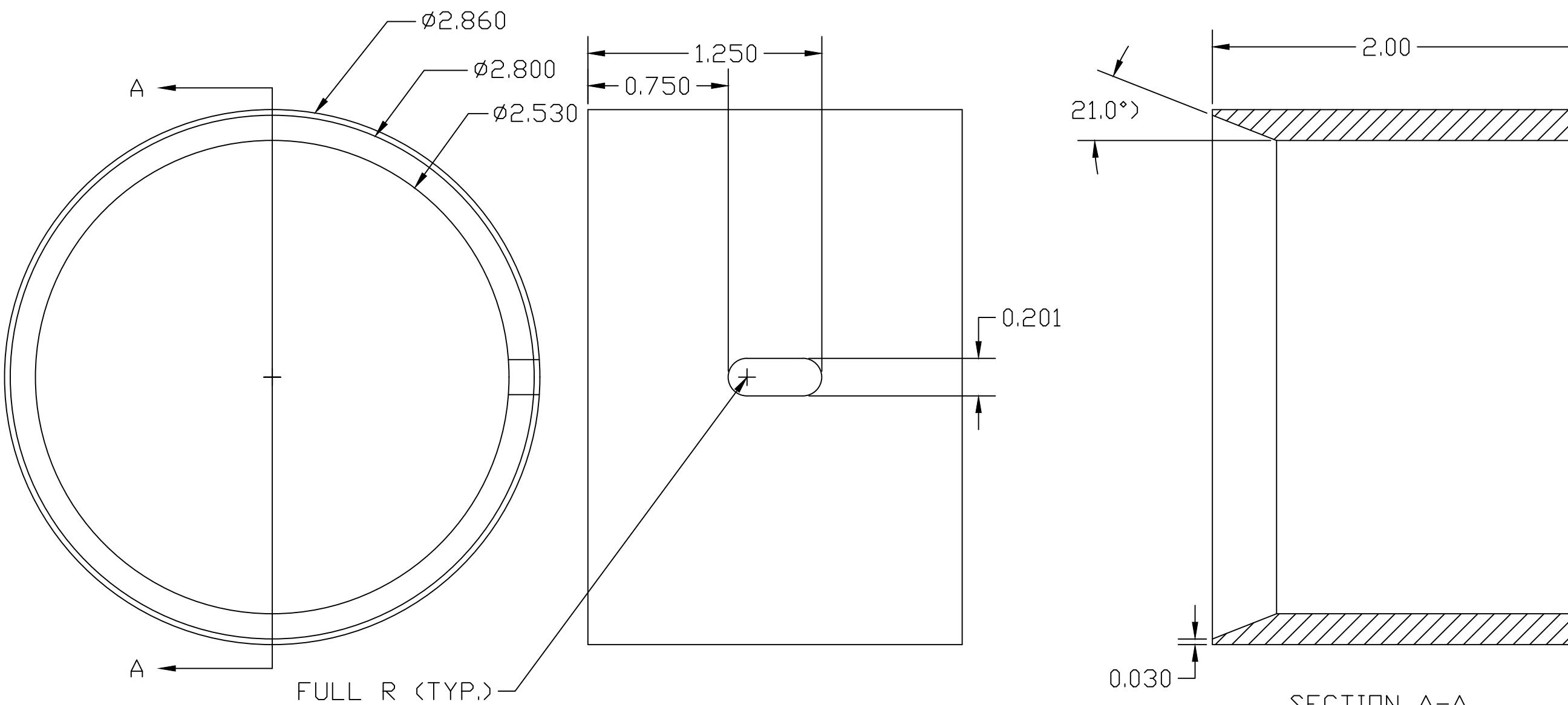
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SECTION A-A

Paravion® Technology Inc.	TITLE			DRAWING NO.						
	SUPPORT ASSEMBLY			IR-1110						
DIMENSIONS IN INCHES										
TOLERANCES EXCEPT WHERE NOTED:										
PROTO	DRAWN BY RHSM	APRVD. BY REB	CHK'D BY REB	DATE 09/06/96	REV F ECO					
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	SHEET 3 OF 5									

MATERIAL: 6061-T6; AMS-WW-T-700/6, AMS4080, AMS4081
STOCK: 3" X 0.375 WALL TUBE
WEIGHT: 0.30 lbs
SURFACE FINISH 125



-11 RING

BREAK ALL SHARP EDGES

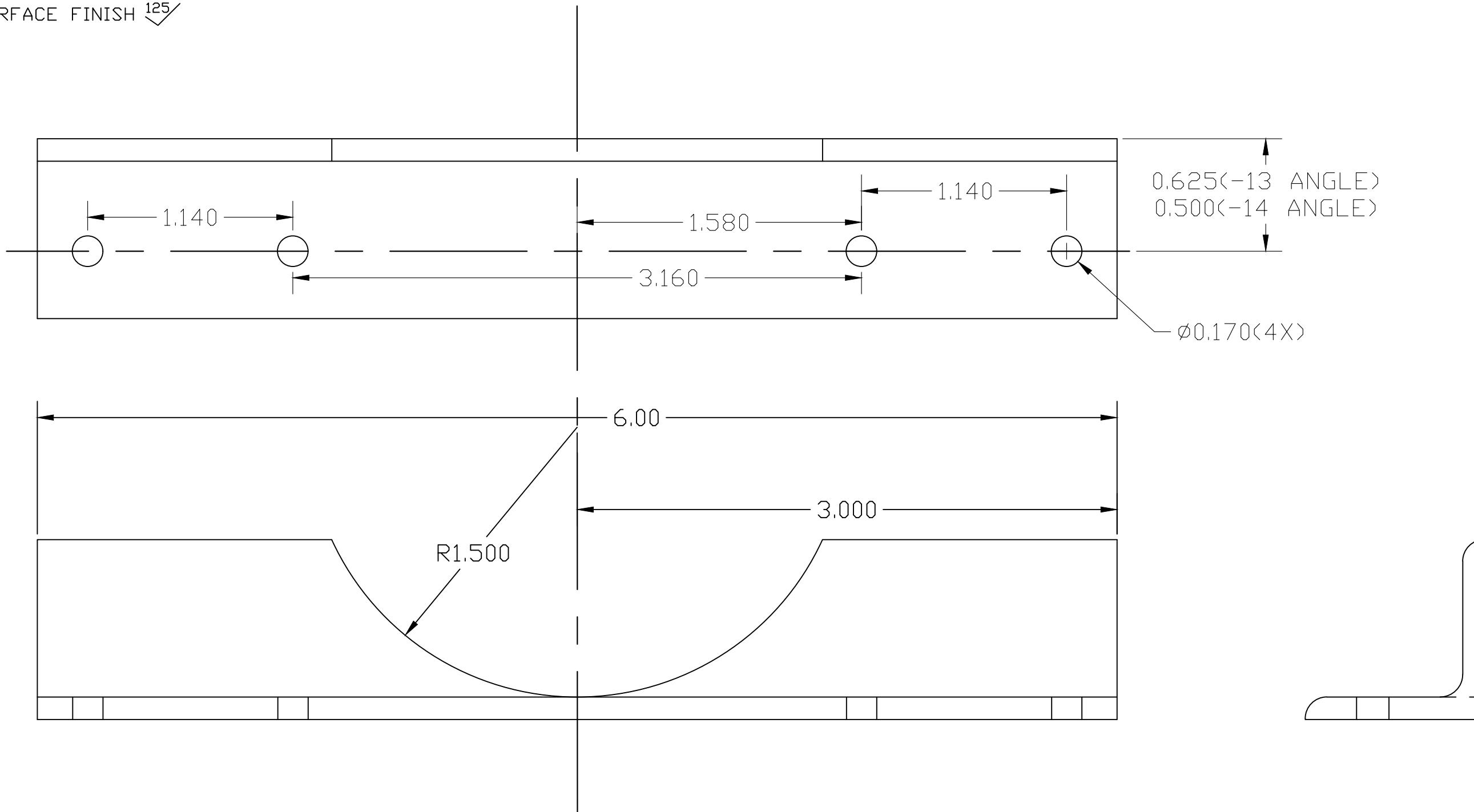
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FORMATION— SERIES

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E PRIOR

Paravion® Technology Inc.		TITLE SUPPORT ASSEMBLY			DRAWING NO. IR-1110		
DIMENSIONS IN INCHES							
TOLERANCES EXCEPT WHERE NOTED:		DRAWN BY RHSM	APRVD. BY REB	CHK'D BY REB	DATE 09/06/96	REV F	ECO
PROTO	$.X = \pm .1$						
	$.XX = \pm .05$						
N/C	$.XXX = \pm .010$						
	$\text{ANGLES} = \pm 1^\circ$						
DO NOT SCALE DRAWING							SHEET 4 OF 5
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MATERIAL: 6061-T6; AMS-QQ-A-200/8, AMS4150, AMS4173
 STOCK: 0.125 X 1 X 1 ANGLE
 WEIGHT: 0.15 lbs
 SURFACE FINISH 125\AA



BREAK ALL SHARP EDGES

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